Date: Wednesday, 3/8/2006 10:34:48 AM
User: Kim Johnston

15

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SKIDTUBE ASSEMBLY LH
Job Number	: 26100		
Estimate Number	: 10266		
P.O. Number	: N/A	Part Number	: D350636013
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D2750 REV C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C1
Previous Run	: 26099	Material	: N/A
Written By	: See comment below	Due Date	: 4/15/2006 Qty: 1 Um: Each
Checked & Approved By	: KJ 06.03.08		
Comment	: Est Rev:H 02.09.25 Rearranged procedure steps KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy blue file and type labels per PPP D350-636-013 CHG 001 DA 06/03/21

Seq. #:	Machine Or Operation:	Description :
2.0	D26003BENT	Extrusion Bent

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2600-3-Bent	Extrusion (Bent)	B25384 Pm 06-03-09 (1)

Seq. #:	Machine Or Operation:	Description :
3.0	D2744	Fwd Cap

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2744	Cap	B24672 BE 06-04-18

Seq. #:	Machine Or Operation:	Description :
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750Mark cut line using Jig DT 8150. Deburr end Pm 06-03-09 (8)

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-3) and mark fwd end for cutting using Drill Jig DT 8150.Second side of Detail B to be Drilled using DT 8330 Pm 06-03-09 (8)
**********Drill last hole using Dt 8820 locating off last hole drilled**********************

3-Open up holes for Detail B, D and 2 aft 0.500" Æ holes to finished size as per Dwg D2750 and DEO 9133Do not open any 0.625" Æ holes to finished size Pm 06-04-10 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:34:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100 | **Part Number:** D350636013

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**

4-Drill pilot holes as per Dwg D2750 (Sheet 3 ,D2750-3),mark Fwd end for cutting using Drill Jig DT8150,then drill both sides.

5-Open holes as per detail "P" To 500",then Drill pilot holes to detail "B" using DT8330
Make sure that wearplate holes are on bottom of tube***

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375"mas per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .391" as per detail "D".

11-Deburr

Pm 06-04-18 (1)

12-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod M19101 BE 06-04-18 (1)

13-Grind welds flush as per Dwg D2750 BE 06-04-18 (1)

5.0 HAND FINISHING1 — HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 Pm 06-04-19 (1)

6.0 QC5/9 — WELD INSPECTION

PD 06-04-19

Comment: WELD INSPECTION DP 06-4-19

7.0 D2739 — 350 I Beam

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2739	Web	B26385

Pm 06-04-19 (1)

H:\FORMS\Quality Assurance\approved QA\NCRWO RevD

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: *Date & initial all entries*

Date: Wednesday, 3/8/2006 10:34:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100
Part Number: D350636013

Job Number:

Seq. #:	Machine Or Operation:	Description :
8.0	D2743	Crossbolt Spacer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
8	D2743	Crossbolt spacer	B25838 BE 06-04-25 (1)

Seq. #:	Machine Or Operation:	Description :
9.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" Æ holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil fm 06-04-19 (1)

2-Deburr and blow out all chips from inside of tube fm 06-04-19 (1)

3-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 M100480
Sikaflex expire date: ~~06-04~~ 06-11-01 fm 06-04-19 (1)

4-Weld crossbolt spacers D2743 as per Dwg D2750and QSI 004
A/R Aluminum Rod M19101 BE 06-04-25 (1)

5-Grind welds flush as per Dwg D2750 BE 06-04-26 (1)

6-Spot face ground handling holes Æ0.750" (8 places) BE 06-04-26 (1)

7-Deburr holes BE 06-04-26 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	QC5/9	WELD INSPECTION

PD 06-04-26 1

Comment: Inspect weld and work to Step 20

Seq. #:	Machine Or Operation:	Description :
11.0	POWDER COATING	POWDER COATING

Comment: POWDER COATING
Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3 DL 06/05/01 (1)

Seq. #:	Machine Or Operation:	Description :
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
Inspect for foreign object per QSI 024 FC 06 05 01 (1)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: *Date & initial all entries*

Date: Wednesday, 3/8/2006 10:34:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100 **Part Number:** D350636013

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D27421	Blade Fitting, LH

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2742-1	Blade Fitting, LH	B2517M ✓

Seq. #:	Machine Or Operation:	Description :
14.0	AN835A	Bolt

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576 ✓

Seq. #:	Machine Or Operation:	Description :
15.0	AN960JD816	1/2" washer,Alum

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956 ✓

Seq. #:	Machine Or Operation:	Description :
16.0	MS21083N8	Nut

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19185 ✓

Seq. #:	Machine Or Operation:	Description :
17.0	D26483	Wearpad

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B24843-2 ✓

Seq. #:	Machine Or Operation:	Description :
18.0	D265613	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	~~B25~~329

G.M 06-05-01 (1)

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: *Date & initial* all entries

Date: Wednesday, 3/8/2006 10:34:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100

Part Number: D350636013

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	D265635	Wearplate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	025330 ✓

Seq. #:	Machine Or Operation:	Description :
20.0	D2746	Wearshoe

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B 24149 ✓

Seq. #:	Machine Or Operation:	Description :
21.0	ALS41032225	Insert

Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 ✓ (or AKS4-1032-225) (or ALS7-1032-225) (or AKS7-1032-225)	Insert	M18293 ✓

Seq. #:	Machine Or Operation:	Description :
22.0	AN960JD10L	Washer

Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M 19185 ✓

Seq. #:	Machine Or Operation:	Description :
23.0	AN35A	Bolt

Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M 15205

a.m 04-05-01

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: *Date & initial all entries*

Date: Wednesday, 3/8/2006 10:34:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100

Part Number: D350636013

Job Number:

Seq. #:	Machine Or Operation:	Description :
24.0	AN36A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274 ✓

Seq. #:	Machine Or Operation:	Description :
25.0	D2745	Bushing

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B25840 (4x) B24879 (4x) ✓

Seq. #:	Machine Or Operation:	Description :
26.0	AN644A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M18369 ✓

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L6	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614 ✓

Seq. #:	Machine Or Operation:	Description :
28.0	AN36A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M110274

arm 06-05-01

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: __________

QA: N/C Closed: _____ Date: __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: *Date & initial all entries*

Date: Wednesday, 3/8/2006 10:34:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100
Part Number: D350636013

Job Number:

Seq. #:	Machine Or Operation:	Description :
29.0	AN960JD10	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M16066

a-m 06-05-01 (1)

Seq. #:	Machine Or Operation:	Description :
30.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.
A/R Sikaflex-291 M100480
Sikaflex expire date: 06-11-06
a.m 06-05-01 (1)

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.
A/R Sikaflex-291 M100480
Sikaflex expire date: 06-11-06 a.m 06-05-01 (1)

3-Install D2745 Bushing as per Dwg. D2750 Detail M a.m 06-05-01 (1)

4-Install AN3-6A Bolt as per Dwg. D2750 Detail Q a.m 06-05-01 (1)

Seq. #:	Machine Or Operation:	Description :
31.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP FC 06 05 02 (1)

Seq. #:	Machine Or Operation:	Description :
32.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit C2060510 1 (1)

Seq. #:	Machine Or Operation:	Description :
33.0	D2741	Blade

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
1	D2741	Blade	B25938

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:34:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 26100
Part Number: D350636013

Job Number:

Seq. #:	Machine Or Operation:	Description :
34.0	AN960JD816	1/2" washer,Alum

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

Seq. #:	Machine Or Operation:	Description :
35.0	MS21083N8	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
2	MS21083N8	Nut	M19099

Seq. #:	Machine Or Operation:	Description :
36.0	AN816A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Kit Picking

Qty	Part Number	Description	Batch
2	AN8-16A	Bolt	M5760

AL 06/05/02

Seq. #:	Machine Or Operation:	Description :
37.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS

06/5/2 (1)

Seq. #:	Machine Or Operation:	Description :
38.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Package as per PPP D350-636-013 Rev D

6/5/2 (1)

Seq. #:	Machine Or Operation:	Description :
39.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

06/05/03 (1)

Job Completion

06.05.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2750 — REV. C — SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY — SCALE NTS

Rev	Date	Description
A	98.04.16	NEW ISSUE
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740
C1	05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED

RELEASED 98.12.16 DS

EFFECTIVE	DEOs
DEO 4133 98.01.19 DS	DEO 9157 97.10.24 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
~~40~~ 38	~~40~~ 38	~~40~~ 38	~~40~~ 38	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
~~44~~ 42	~~44~~ 42	~~44~~ 42	~~44~~ 42	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
~~44~~ 42	~~44~~ 42	~~44~~ 42	~~44~~ 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

C1 (revision marks beside the AN3-5A, AN960JD10L and insert rows)

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 26100

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED	APPROVED	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:
   THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
   MINIMUM YIELD TENSILE STRENGTH = 35 ksi
   MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:
   ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

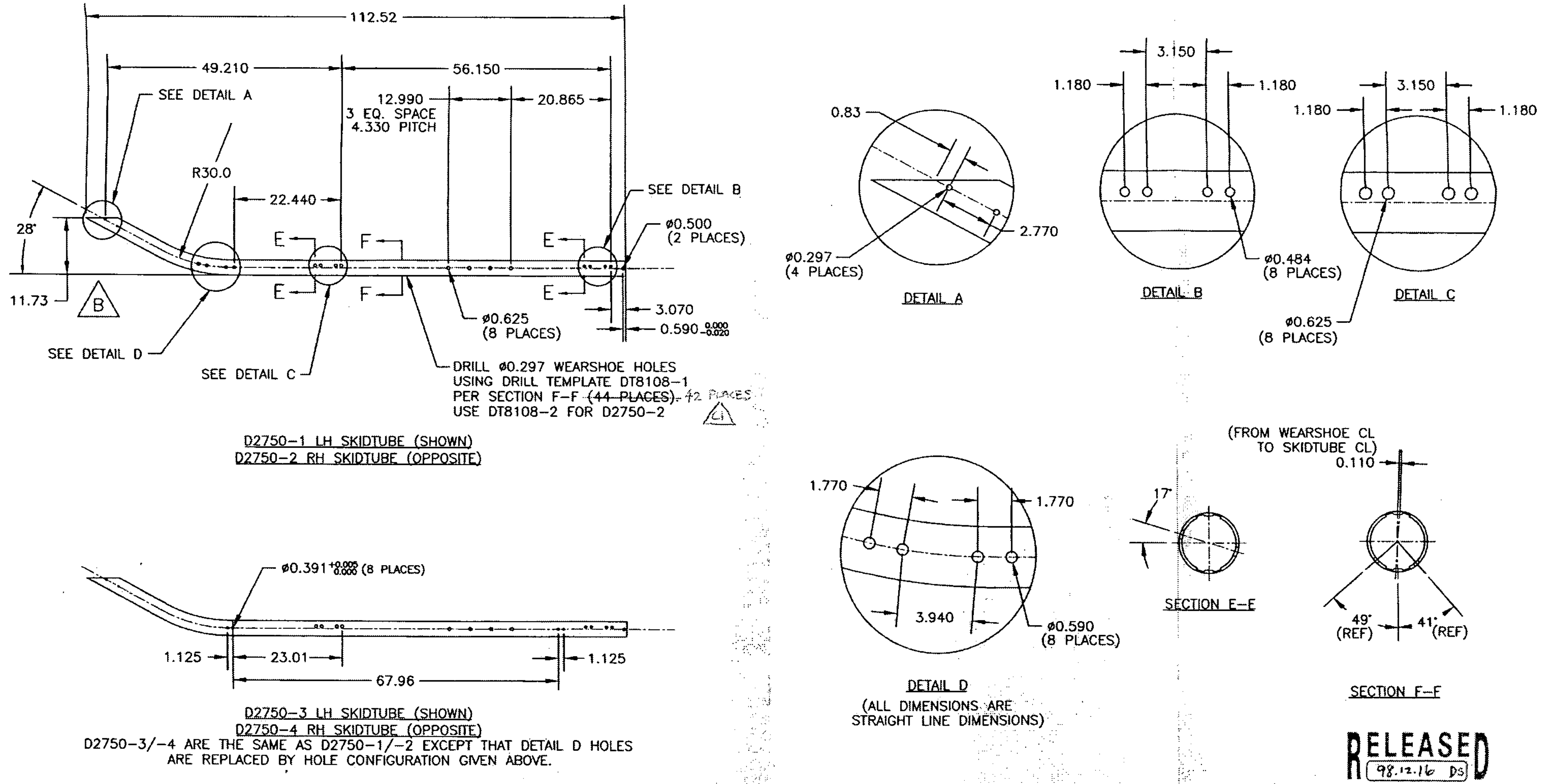
EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS

RELEASED 98.12.16 DS

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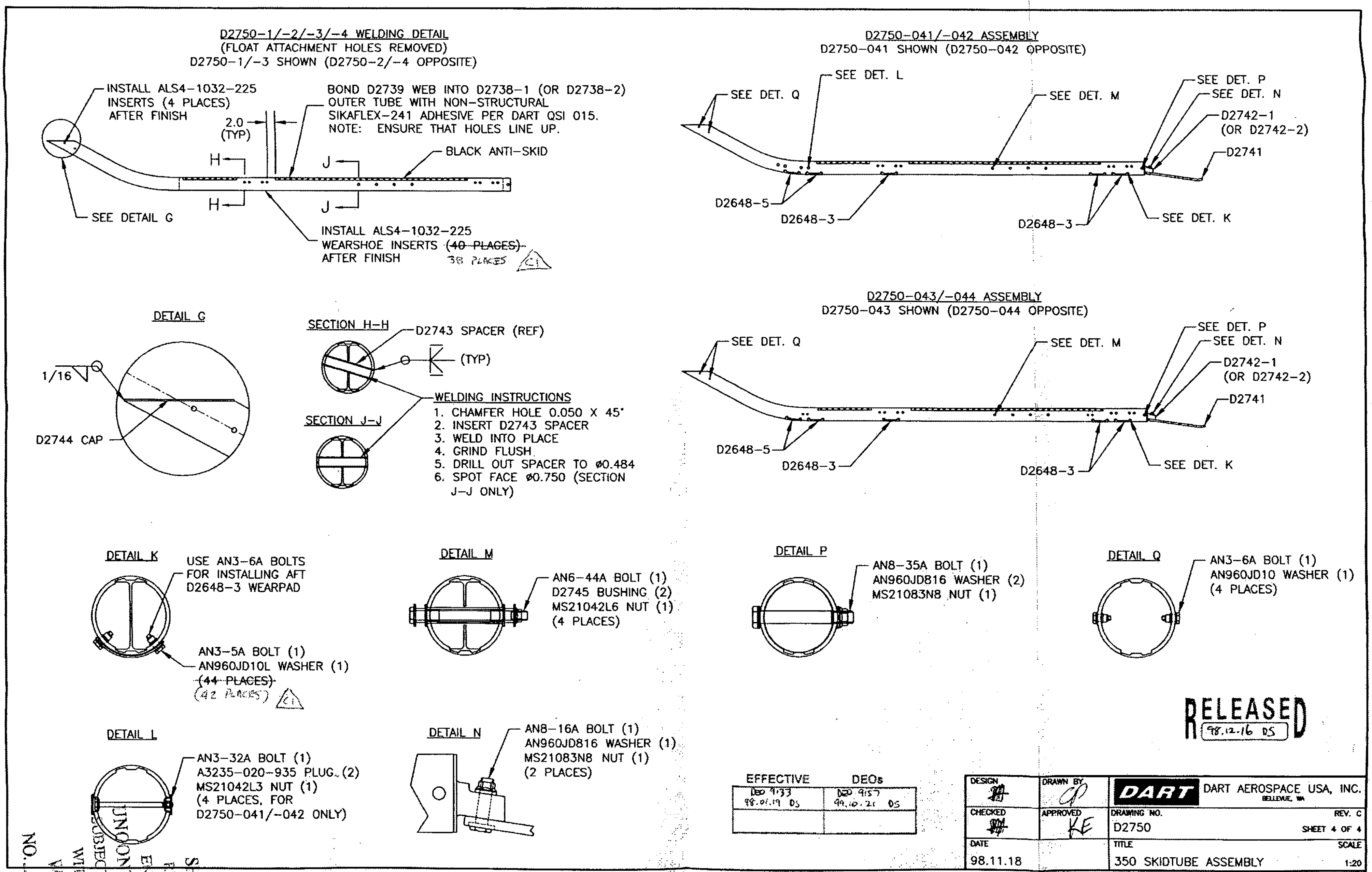
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WORK ORDER NO 26100



EFFECTIVE	DEOs
DEO 9133 98.01.19 DS	DEO 9157 99.10.21 DS

DESIGN	DRAWN BY	DART — DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2750 — REV. C — SHEET 3 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY — SCALE 1:20


D2750-1/-2/-3/-4 WELDING DETAIL
(FLOAT ATTACHMENT HOLES REMOVED)
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)
INSTALL ALS4-1032-225 INSERTS (4 PLACES) AFTER FINISH
2.0 (TYP)
BOND D2739 WEB INTO D2738-1 (OR D2738-2) OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.
BLACK ANTI-SKID
H
J
SEE DETAIL G
INSTALL ALS4-1032-225 WEARSHOE INSERTS (40 PLACES) AFTER FINISH
38 PLACES
C1
D2750-041/-042 ASSEMBLY
D2750-041 SHOWN (D2750-042 OPPOSITE)
SEE DET. Q
SEE DET. L
SEE DET. M
SEE DET. P
SEE DET. N
D2742-1 (OR D2742-2)
D2741
D2648-5
D2648-3
D2648-3
SEE DET. K
D2750-043/-044 ASSEMBLY
D2750-043 SHOWN (D2750-044 OPPOSITE)
SEE DET. Q
SEE DET. M
SEE DET. P
SEE DET. N
D2742-1 (OR D2742-2)
D2741
D2648-5
D2648-3
D2648-3
SEE DET. K
DETAIL G
1/16
D2744 CAP
SECTION H-H
D2743 SPACER (REF)
(TYP)
SECTION J-J
WELDING INSTRUCTIONS
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO ø0.484
6. SPOT FACE ø0.750 (SECTION J-J ONLY)
DETAIL K
USE AN3-6A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD
AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)
(42 PLACES)
C1
DETAIL M
AN6-44A BOLT (1)
D2745 BUSHING (2)
MS21042L6 NUT (1)
(4 PLACES)
DETAIL P
AN8-35A BOLT (1)
AN960JD816 WASHER (2)
MS21083N8 NUT (1)
DETAIL Q
AN3-6A BOLT (1)
AN960JD10 WASHER (1)
(4 PLACES)
DETAIL L
AN3-32A BOLT (1)
A3235-020-935 PLUG (2)
MS21042L3 NUT (1)
(4 PLACES, FOR D2750-041/-042 ONLY)
DETAIL N
AN8-16A BOLT (1)
AN960JD816 WASHER (1)
MS21083N8 NUT (1)
(2 PLACES)
RELEASED
98.12.16 DS
EFFECTIVE DEOs
DEO 9133 98.07.19 DS
DEO 9157 99.10.21 DS
DESIGN
DRAWN BY
CHECKED
APPROVED
DATE
98.11.18
DART
DART AEROSPACE USA, INC.
BELLEVUE, WA
DRAWING NO.
D2750
REV. C
SHEET 4 OF 4
TITLE
350 SKIDTUBE ASSEMBLY
SCALE
1:20